

Work Order ID 48113

June 26, 2009 7:24:47 AM



Page 1

Item ID: D3065-041

Accept



Setup Start



Revision ID: B

Stop



Item Name: Step Leg Assembly Hi

Start Date: 15/07/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3065

Rev B

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D3065 and Identify as D3065-041

EB 09/06/30

(40)

110

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

SB 09/06/30

(40)

120

0.00



Identify as per dwg & Stock Location: WA

Packaging

Memo

0.00

Packaging

SAP 09-07-01

(40)

Work Order ID 48113

June 26, 2009 7:24:47 AM



Page 2

Item ID: D3065-041

Accept



Setup Start



Revision ID: B

Item Name: Step Leg Assembly Hi

Stop



Start Date: 15/07/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/09 *[Signature]*
MF 09-07-08

June 26, 2009 7:24:46 AM

Parent Item: D3065-041Rev.B

Parent Item Name: Step Leg Assembly Hi

Comments:

Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 40.00

Required Qty: 40.00

[illegible]

Date: Friday, 22/05/2009 8:58:52 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HI-STEP LEG ASSEMBLY
Job Number : 48113	
Estimate Number : 10385	
P.O. Number :	Part Number : D3065041
This Issue : 22/05/2009 S.O. No. :	Drawing Number : D3065 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 47090	Material :
Written By :	Due Date : 28/05/2009 Qty: 40 Um: Each
Checked & Approved By : <u>22.05.09</u>	
Comment : Est Rev: C 02.11.01 Incorporated D3066-1 IPP KJ/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	✓ 48113A	STEP SPACER
-----	----------	-------------

**Comment:** Sub-Component STEP SPACER

1 x D3065-1 Batch _____

2.0	✓ 48113B	STEP SPACER
-----	----------	-------------

**Comment:** Sub-Component STEP SPACER

1 x D3065-3 Batch _____

3.0	✓ 48113C	STEP LEG
-----	----------	----------

**Comment:** Sub-Component STEP LEG

2 x D3065-5 Batch _____

4.0	✓ 48113D	STEP SPACER
-----	----------	-------------

**Comment:** Sub-Component STEP SPACER

1 x D3065-7 Batch _____

5.0	✓ MS20470AD44	Rivet, Universal Head
-----	---------------	-----------------------

**Comment:** Qty.: 30.0000 Each(s)/Unit Total : 1200.0000 Each(s)

Rivet, Universal Head

Pick:

Qty	Part Number	Description	Batch
30	MS20470AD4-4	Rivet	_____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 22/05/2009 8:58:53 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HI-STEP LEG ASSEMBLY

Job Number: 48113

Part Number: D3065041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0



SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3065 and Identify as D3065-041

7.0



QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0



PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

9.0



QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

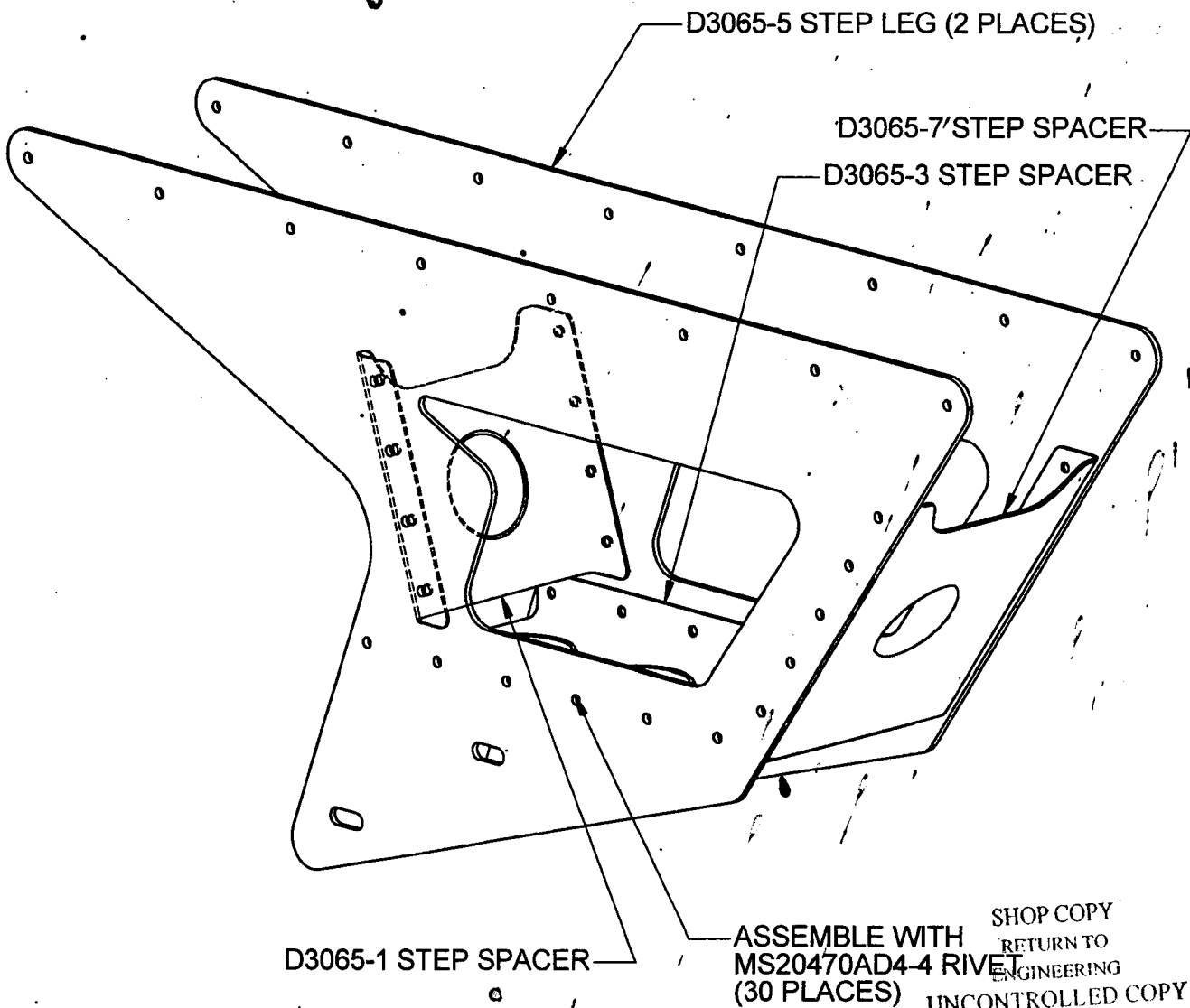
NOTE: Date & initial all entries



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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED

06.06.20 *[Signature]*

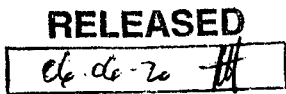
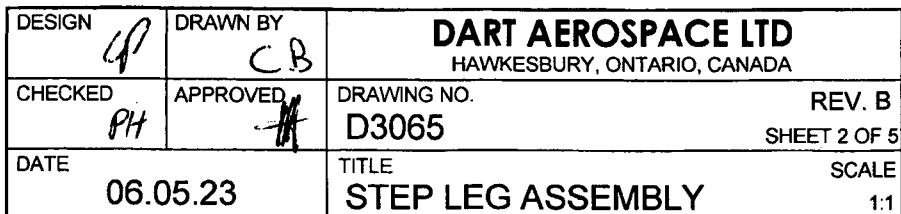


D3065-041 STEP LEG ASSEMBLY

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BEND DETAIL

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M20)
2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
3) BREAK ALL SHARP EDGES 0.005 TO 0.010
4) PART IS SYMMETRIC ABOUT CENTERLINE
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES

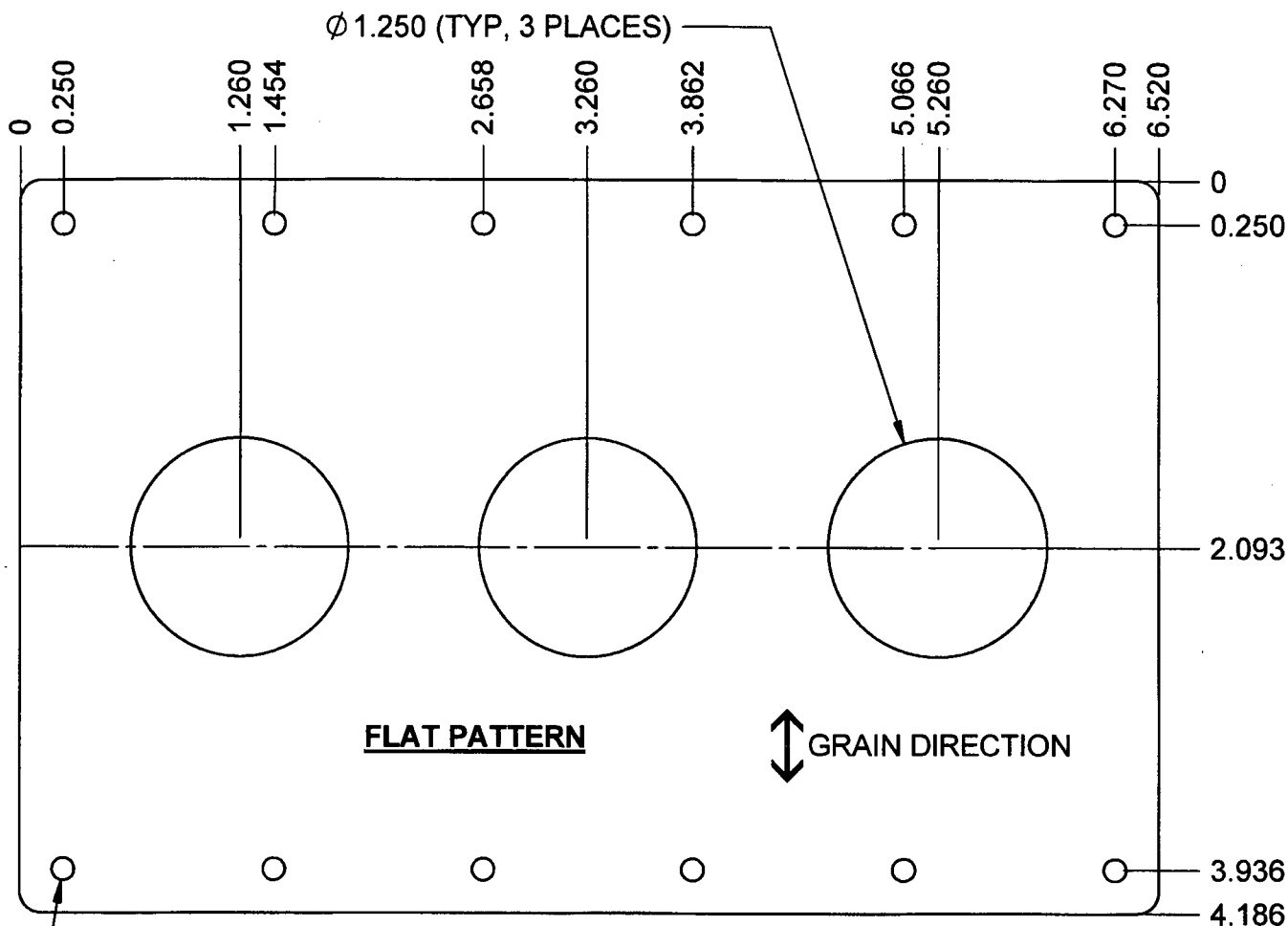
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T3S:040) TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 48113

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 3 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

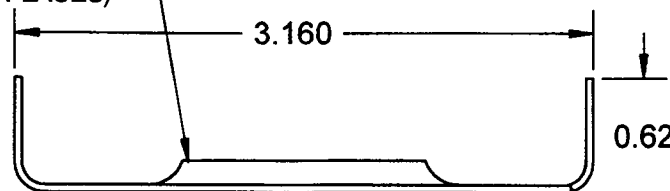


FLANGE AFTER TOWARDS SIDE
SHOWN USING DT8174 (3 PLACES)

Ø 0.129 (TYP, 12 PLACES)

RELEASED

ck ck 20 [Signature]



BEND DETAIL

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ENGINEERING

D3065-3 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

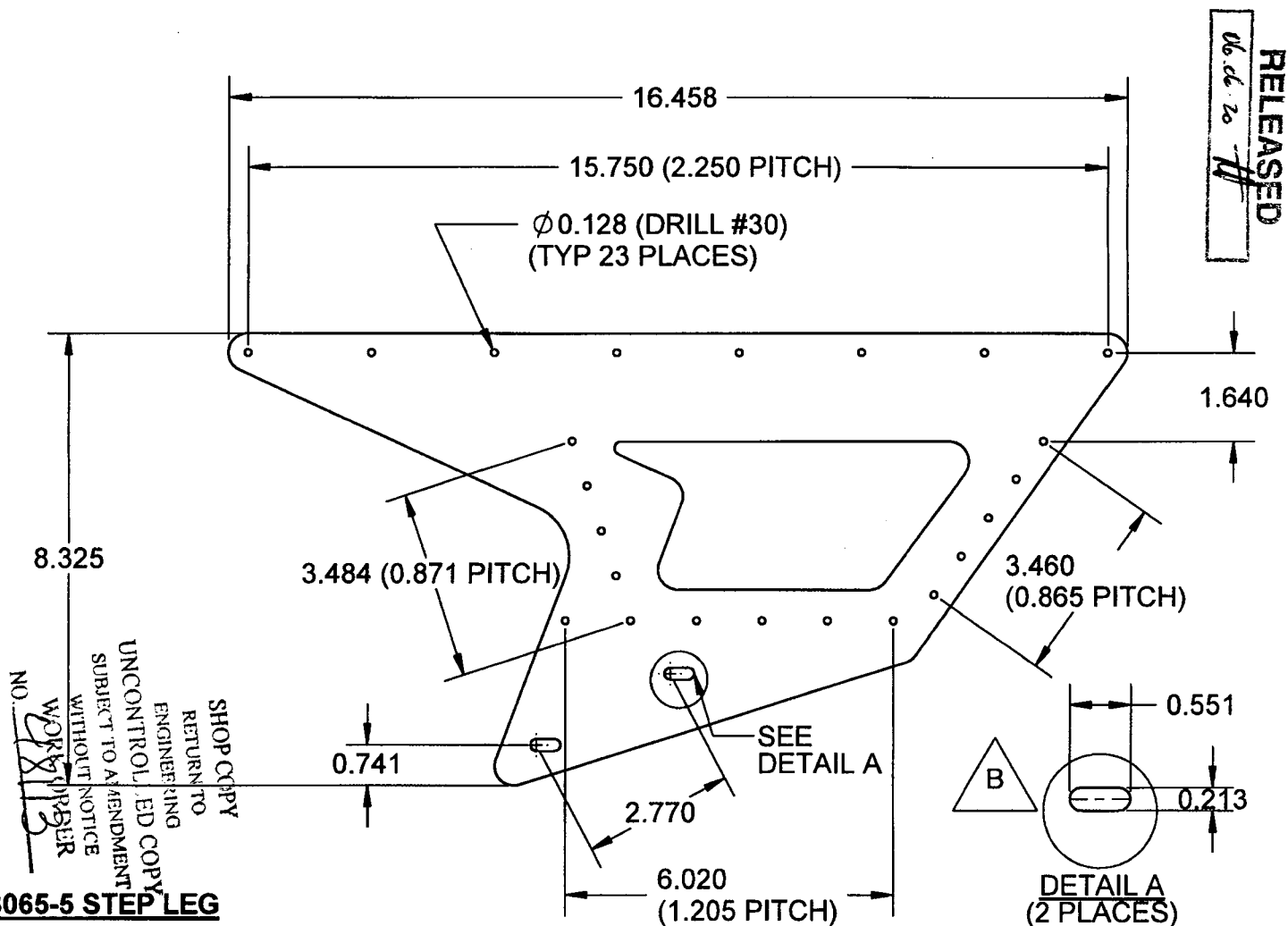
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DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
C.P.	C.B.	DRAWING NO.	REV. B	
CHECKED H4	APPROVED H4	D3065	SHEET 4 OF 5	
DATE 06.05.23	TITLE STEP LEG ASSEMBLY		SCALE 1:3	

**D3065-5 STEP LEG**

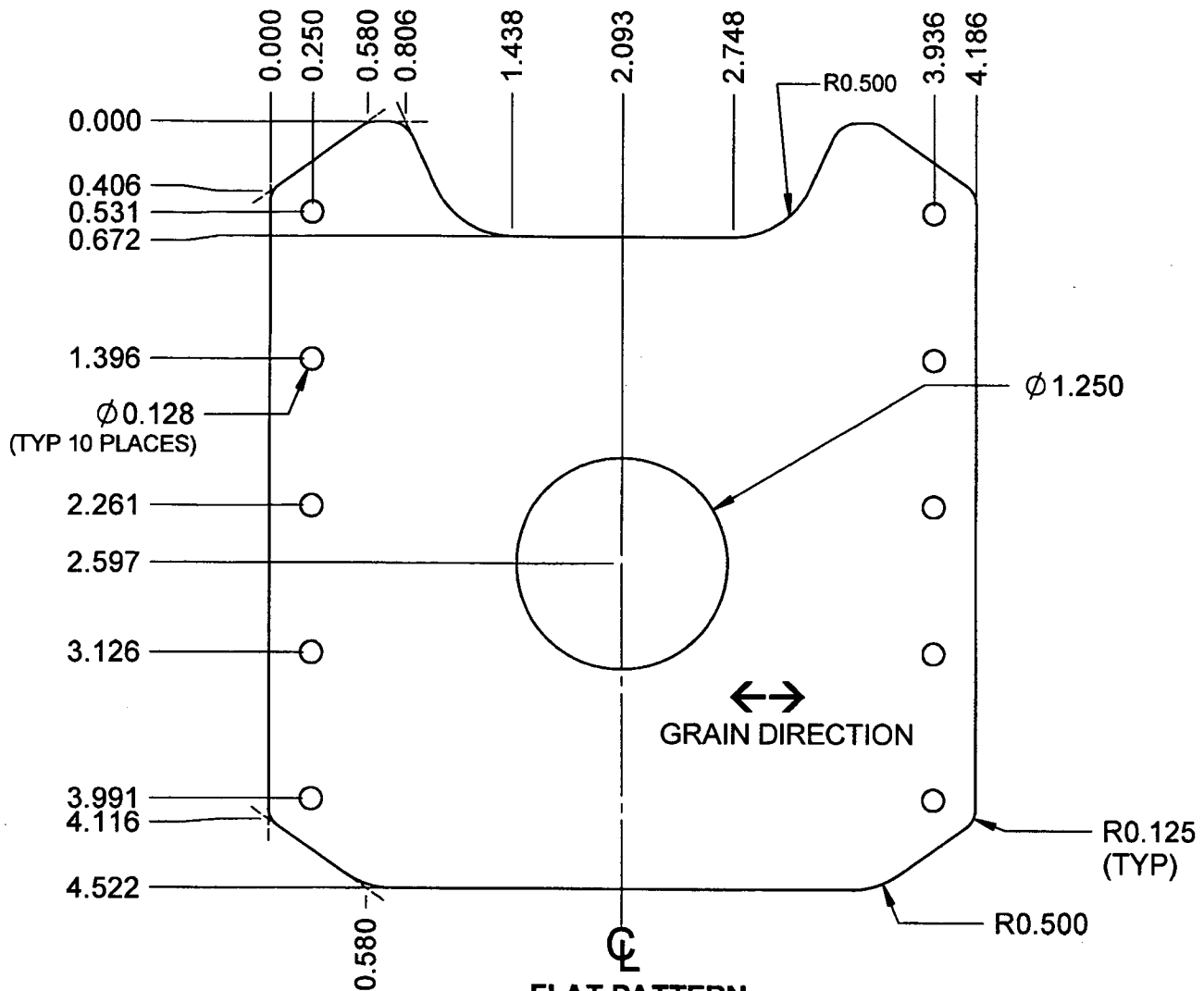
- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 5 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

**RELEASED***de de 20***D3065-7 STEP SPACER**

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S 040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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